

Amendments to the Specification

Please replace paragraphs [0018]-[0020] with the following amended paragraphs:

[0018] The FIGS. 1 through 3 show a metering unit 1, also referred to as a dosing unit 1, which is constructed as a crucible insert, and which can be introduced into a metal melt 4 through the upper cover 2 of a melting crucible 3, wherein the level of the melt on the level indicator is maintained by a means that is not shown in the figure. The cover 2 of the crucible is equipped with an opening 7, which is closed by a lid 6 in a known manner, enabling the refilling of the unit with the material to be melted through the opening.

[0019] The crucible insert 1 comprises, in particular as one can see from Fig. 2 and Fig. 3, a cover flange 8, also referred to as lid flange 8, which can be placed upon the crucible cover 2, and which is equipped with penetrating openings 31, 32 for a pump pipe 11, which can be introduced vertically to the lid flange 8, or with a discharge pipe 12, which can be also introduced vertically to the lid flange 8. As shown in Fig. 1 and Fig. 2, the discharge pipe 12 is in this case provided at about half of the height with an outlet connection 13, also referred to as a discharge neck 13, which is bent and slightly inclined in the downward direction, and which forms at the upper part of its inner edge 13a an overflow edge for the pump pipe 11 from the supplied melt material. The lower end of the discharge pipe 12 is connected by a type of a plug connection 14 to a U-shaped connecting pipe 15, which is in turn connected in a fixed manner by a tubular holder 16 to the lid flange 8. The U-shaped connecting pipe 15 is also equipped on the side of the pump pipe 11 with a plug connection 17, through which it is firmly connected to the lower end of the pump pipe 11.

[0020] As one can clearly see from the figure, a driving shaft 18 is mounted in the pump pipe 11 in such a way so that it is rotatable. The driving shaft 18 is provided at its lower end below a bearing 20 with a metering pump, formed by openings 23 and a pump screw 21 or the like. Several openings 23 are arranged in the pipe on the circumference of the pump pipe 11 above the pump screw so that the melt 4 can enter inside the pipe in the direction indicated by arrow 24. The melt is then supplied through the connecting pipe 15 in the direction of the arrow 25 to the overflow edge 13a and from there through the discharge neck 13 to a casting apparatus, not shown in the figure. It is clear that with the corresponding application of the drive driving-motor 19, a precise dosage amount of the melt can be output through the discharge neck 13.

Please replace paragraph [0022]-[0023] with the following amended paragraph:

[0022] As one can further also see from the figures, the discharge pipe 12 is equipped in the area above the discharge neck 13 with a supply connection piece 28 for supplying of [[the]] a protective gas or a shielding gas, which makes it possible to prevent in this manner the output melt from being subject to the danger of oxidation during its passage through the discharge pipe.

[0023] It is essential, as one can see in particular from Fig. 3, that the discharge pipe 12 and the discharge neck 13, which is connected in a fixed manner to this pipe, are arranged so as to be pivotable about the axis 30, which is coincident with the axis of the discharge pipe 12 in the direction indicated by arrow 29. This is achieved when the discharge pipe 12, including the

thermal or heat insulation 26, is held in the opening 31 of the lid flange 8 in a pivotable manner, which occurs in each case thanks to the arrangement of the couplings 9 or rings 10.